

SPLIT-2

Dart Aerospace Ltd.

Date: Thursday, 01/05/2008 11:56:53 AM
 User: dulle Lccocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 38941		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 01/05/2008 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 38254	Material	:
Written By	:	Due Date	: 10/05/2008 Qty: 100 Um: Each
Checked & Approved By	: <u>JD 08-5-01</u>		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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16



Comment: Qty.: 0.1113 sf(s)/Unit Total: 11.1300 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 07772

HB 8-5-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

HB 8-5-5

Prog Rev: C

2-Deburr if necessary

HB 8-5-5

(119)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-5-5



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/05/05 (119) cants

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

HB 08/05/06 (119)



Date: Thursday, 01/05/2008 11:56:53 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 38941

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description
2059B Hardcoat

Batch
M106834 + M108631

119-72-47

EZ (47) 8-8-14

1-Remove per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

08/06/20

72x

QC10

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/08/14 (47)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/14 (47)

9.0

POWDER COATING

POWDER COATING



M106442



(47X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:00

OVEN TEMPERATURE:

320 °F

FINISH TIME:

10:30

M.H. 08/08/18

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-08-18 (47)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-17

BR 08-08-18 (47)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/19

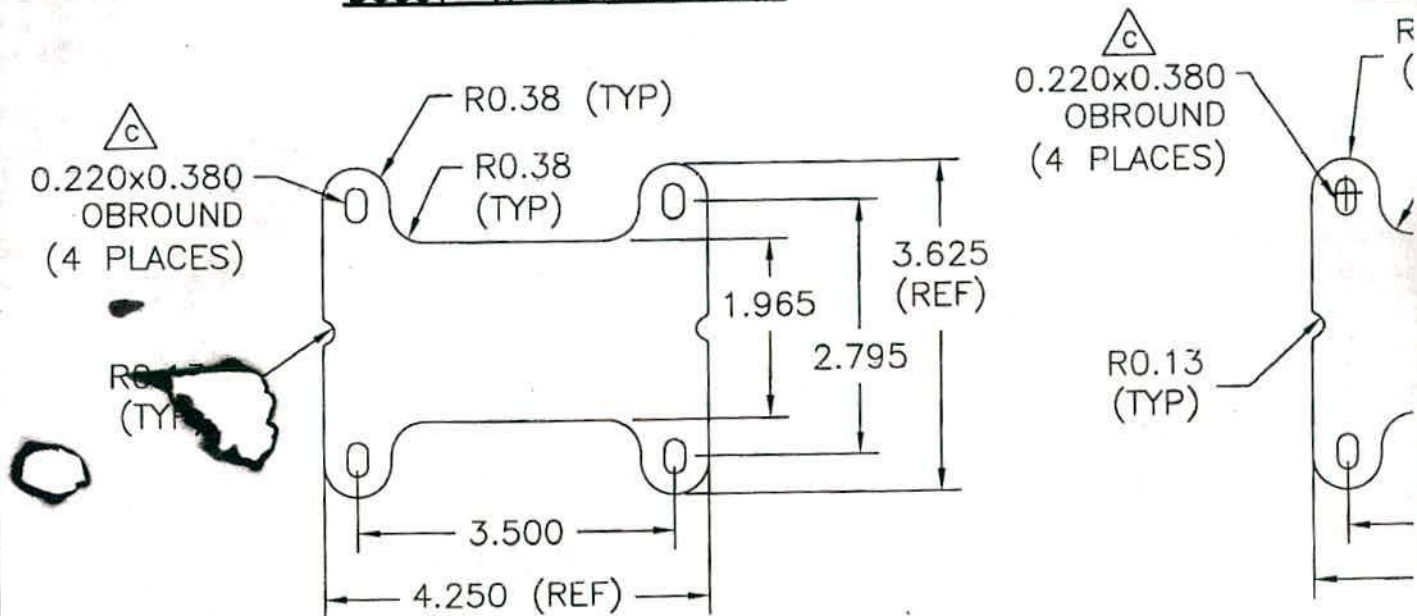
Job Completion



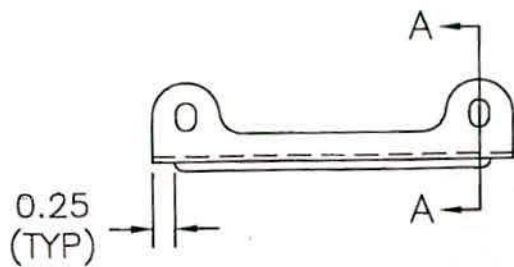
MF 08-08-18



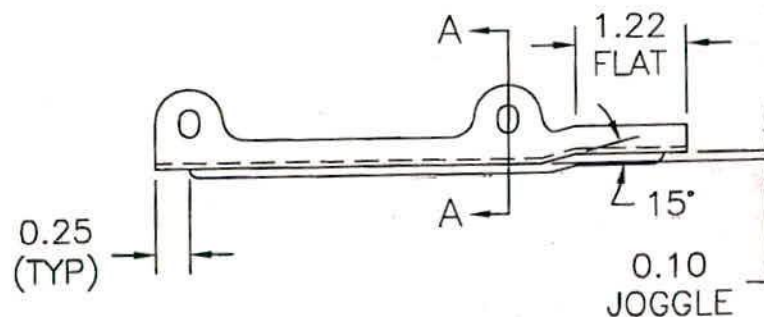
D3537-1F FLAT PATTERN



D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)

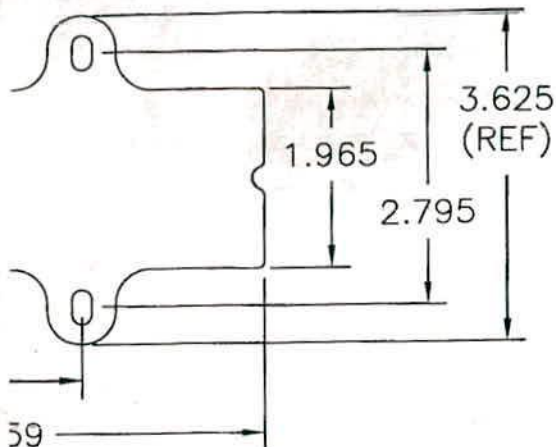


D3537-1/-3/-5/-7 WEARPAD NOTES

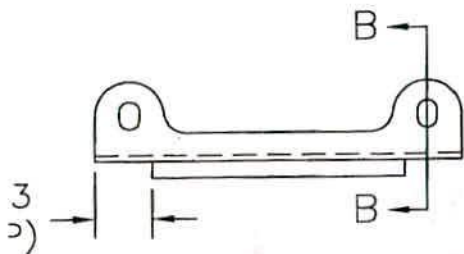
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



AT PATTERN

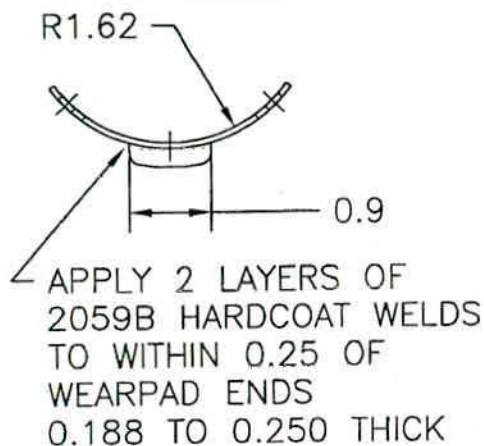


D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

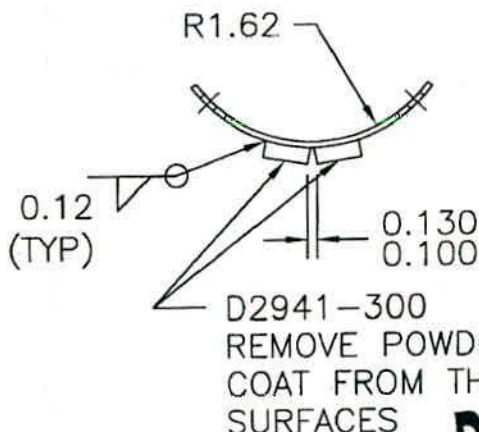


0.063 THICK)

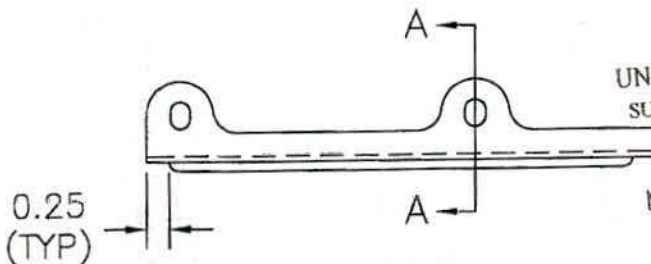
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED
07.05.08 PH
per ELN
962

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3841

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD

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DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. C

SHEET 1 OF 1

SCALE

1:2

